

ABSTRACT

The method according to the invention for riveting, or self-piercing, by means of a riveting or self-piercing device (8), having a male die (3) guided by a pick-up device (4), both of which in each case can be moved towards a female die (5) and/or a workpiece (6), wherein the female die (5) and riveting or self-piercing device (8) will be connected to one another via a counterforce structure (9). The relative movement between the pick-up device (4) and the counterforce structure (9) is measured by a first sensor (1), and the relative movement between counterforce structure (9) and male die (3) is measured by a second sensor (2). The depth of the riveting or piercing is adjusted with the aid of the two measured values. The associated device allows fast, accurate detection of the thickness of a workpiece (6) and precise piercing or riveting with constant predetermined depth irrespective of variations in the quality of the material or other parameters, which can result in deformations of the counterforce structure (9) during the piercing process.